



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

MAY 16 2018

DAS  
13  
9-89

RBEGM-745-064  
Job Sheet 175829



Part No: RBEGM-745-064

Job Qty: 1 ea

Part Name: Removal/Installation-Motor Pump Cartridge (Forward Main Tank)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEGM-745-064 Rev 0 IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |            |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 100   | Purchasing | 1 pcs |            | 5/17/18  | 0.00      | 0.00    | Purchasing            |           | AP 18/05/18  |
| 110   | Packaging  | 1 pcs |            | 5/17/18  | 0.00      | 0.00    | Packaging2            |           | AP 18/05/18  |
| 120   | QC         | 1 pcs |            | 5/17/18  | 0.00      | 0.00    | QC6                   |           | 38 9-89      |
| 130   | Small Fab  | 1 pcs |            | 5/18/18  | 0.00      | 0.50    | Small Fab-4           |           | MLC          |
| 140   | QC         | 1 pcs |            | 5/18/18  | 0.00      | 0.00    | QC5                   |           | PD 18-05-18  |
| 150   | Packaging  | 1 pcs |            | 5/18/18  | 0.00      | 0.00    | Packaging3-1          |           |              |
| 160   | QC21-FG    | 1 Ea  |            | 5/18/18  | 0.00      | 0.00    | QC21                  |           | CMF 18/05/18 |

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 39520 MANUFACTURE RBEGM-745-064 AS PER

Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

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### Job BOM

| Part / Item      | Component Name                                                | Quantity    | Operation      | Container         |
|------------------|---------------------------------------------------------------|-------------|----------------|-------------------|
| RBEGM-745-064P   | Removal/Installation-Motor Pump Cartridge (Forward Main Tank) | 1 (1 ea)    | 100-Purchasing | 5071214           |
| 97524A032        | Blind Rivet                                                   | 4 Ea (4 ea) | 130-Small Fab  | 5031249           |
| APP-1400-E       | Case                                                          | 1 Ea (1 ea) | 130-Small Fab  | 5072424 & 5072425 |
| RB41011          | Dart Tooling Placard, Aluminum                                | 1 Ea (1 ea) | 130-Small Fab  | 5021040           |
| RBEGM-745-064-35 | Bottom Tool Cushion                                           | 1 (1 ea)    | 130-Small Fab  | 5072426 & 5072427 |
| RBEGM-745-064-37 | Top Tool Cushion                                              | 1 (1 ea)    | 130-Small Fab  | 5072428 & 5072429 |

### Job Allocations

| Operation      | Component Part   | Required | Inventory | Allocated |
|----------------|------------------|----------|-----------|-----------|
| 100-Purchasing | RBEGM-745-064P   | 1        | 0         | 0         |
| 130-Small Fab  | 97524A032        | 4        | 207       | 0         |
|                | APP-1400-E       | 1        | 0         | 0         |
|                | RB41011          | 1        | 930       | 0         |
|                | RBEGM-745-064-35 | 1        | 0         | 0         |
|                | RBEGM-745-064-37 | 1        | 0         | 0         |

### Part Specifications

Specifications could not be found.



**Container No: S071217**



**Part: RBEGM - 745 - 064**

**Job No: 175829**

**Serial No/Batch: S071217**

**Revision: 0**

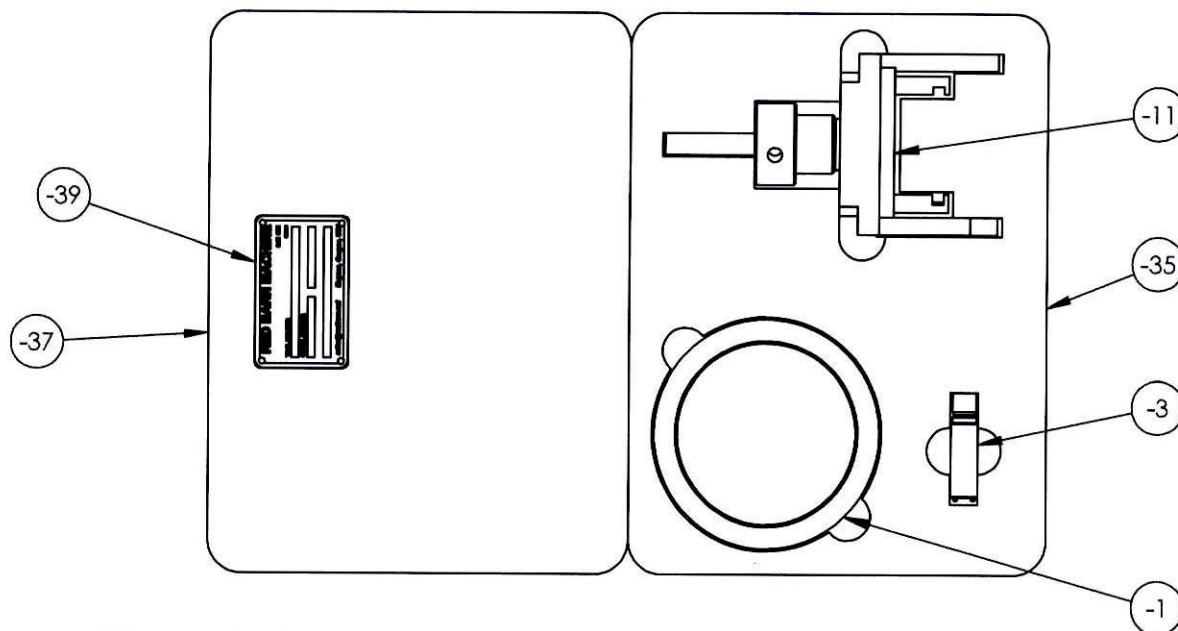
**Inspector:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 05/18/18

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| REVISIONS |             |      |         |
|-----------|-------------|------|---------|
| REV       | DESCRIPTION | DATE | INITIAL |
|           |             |      |         |



| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description           | Material         | B/O INFORMATION OR SPECIFICATIONS              | PG. |
|----------|----------|-----|--------|----------|-----------------------|------------------|------------------------------------------------|-----|
|          |          |     | -1     | 1        | RING                  | 6061             | Ø5 X 1/4                                       | 2   |
|          | X        |     | -3     | 1        | SOCKET WELDMENT       |                  |                                                | 3   |
|          | 1        |     | -5     |          | BASE                  | 4140 Q & T       | Ø5/8 X 2-3/8                                   | 4   |
|          | 1        |     | -7     |          | SOCKET                | STEEL            | 1/4 DRIVE 3/8 GRAINGER #6ECZ3(MODIFIED)        | 5   |
|          | 2        | B/O | -9     |          | DOWEL PIN             | STEEL            | 2mm X 10mm MCMaster-CARR #91595A026            | 3   |
| X        |          |     | -11    | 1        | PULLER ASSY           |                  |                                                | 6   |
| 1        |          |     | -13    |          | TOP                   | 6061             | 1 X 1-5/8 X 4                                  | 7   |
| 1        |          |     | -15    |          | SIDE                  | 6061             | 3/8 X 1-5/8 X 2-5/8                            | 8   |
| 1        |          |     | -17    |          | SIDE 2                | 6061             | 3/8 X 1-5/8 X 2-5/8                            | 9   |
| 1        |          |     | -19    |          | KNOB                  | 6061             | Ø1-7/8 X 1-7/8                                 | 10  |
| 1        |          |     | -21    |          | CROSS BRACE           | 1018             | 5/16 X 7/8 X 3-7/8                             | 11  |
| 2        |          |     | -23    |          | ROD                   | STRESS PROOF     | Ø1/2 X 1-1/4                                   | 12  |
| 1        |          |     | -25    |          | STUD                  | STEEL            | M12 x 1.75 MCMaster-CARR #99055A135 (MODIFIED) | 13  |
| 1        | B/O      |     | -27    |          | BEARING               | STEEL            | FAG 51102                                      | 6   |
| 4        | B/O      |     | -29    |          | SOCKET HEAD CAP SCREW | STEEL            | M4 x .07 X 16 MCMaster-CARR #95263A273         | 6   |
| 2        | B/O      |     | -31    |          | SOCKET HEAD CAP SCREW | STEEL            | M4 x .7 X 12 MCMaster-CARR #95263A260          | 6   |
|          | B/O      |     | -33    | 1        | CASE                  |                  | PELICAN #APP-1400-E                            | NS  |
|          |          |     | -35    | 1        | BOTTOM TOOL CUSHION   | Y-20, BLACK      | 3.95 X 9.08 X 11.98                            | 14  |
|          |          |     | -37    | 1        | TOP TOOL CUSHION      | C200 FLAT, BLACK | 1.2 X 9.08 X 11.98                             | 15  |
|          | B/O      |     | -39    | 1        | RED BARN PLACARD      | ALUMINUM         | RB41009                                        | NS  |

**RED BARN MACHINE**

**FUEL CARTRIDGE PULLER**

DWG NO. **RBEGM-745-064**

REV

MAT'L **DRAWN BY: GILBERT**

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
.XXX ± .005 FRACTIONS ± 1/32  
.XX ± .01 ANGLES ± .5°  
.X ± .1

APPROVED *D Weel*

HEAT  
TREAT  
FINISH

SPEC

USED ON MODEL

EC135

1. BREAK ALL SHARP EDGES .015 x 45°  
OR .015R  
2. DIMENSIONAL LIMITS APPLY AFTER  
PLATING

SCALE 1:4

DATE 5/3/2012

SHEET 1 OF 15





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO039580**

**Supplier:** ARR002-VU  
Arrow Tech Machine Works  
29751 E. Enid Road,  
Unit C  
Eugene, OR 97402 USA  
Phone: 541-780-6938  
Fax: 458-215-4938

**PO No:** PO039580

**PO Date:** 4/11/18

**Due Date:** 6/2/18

**Purchase Order**

**Revision:**

**Revision Date:**

**Ship-To Contact:** Phone:

**Pymt Terms:** Net 30

**Freight Terms:**

**Special Comments:**

*REVISED*

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**Ship To:**

## **Items**

| Line Item | Part                | Supplier Part No | Item No | Description                                                                                                | Status | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (USD) | Extended Price |
|-----------|---------------------|------------------|---------|------------------------------------------------------------------------------------------------------------|--------|----------|----------------|-------------------|---------|------------------|----------------|
| 1         | RBEGM-745-064P      |                  |         | Removal/Installation-<br>Motor Pump<br>Cartridge (Forward<br>Main Tank)<br><br>WO 175829 AND<br>WO 175826  | Firmed | 5/11/18  | 2 Ea           | 0 Ea              | 2 Ea    | \$1,736.93/Ea    | \$3,473.86     |
| 2         | RBW109-3130-85-133P |                  |         | Tool Kit, Tail Rotor<br>Pitch Control Shaft<br>Bearing<br>Remove/Install<br><br>WO 175827 AND<br>WO 175893 | Firmed | 5/25/18  | 2 Ea           | 0 Ea              | 2 Ea    | \$1,766.68/Ea    | \$3,533.36     |
| 3         | RBEL133M-6503-101P  |                  |         | Mounting Tool                                                                                              | Firmed | 5/18/18  | 2 Ea           | 0 Ea              | 2 Ea    | \$1,753.73/Ea    | \$3,507.46     |
| 4         | RBD29828P           |                  |         | Elastomeric Bearing<br>Removal Tool<br><br>WO 175825                                                       | Firmed | 6/4/18   | 2 Ea           | 0 Ea              | 2 Ea    | \$551.91/Ea      | \$1,103.82     |
| 5         | RBW6305G00431-3GP   |                  |         | Hoisting Flange<br>Main Gear Box<br><br>WO 175830                                                          | Firmed | 5/29/18  | 4 pcs          | 0 pcs             | 4 pcs   | \$1,013.90/pcs   | \$4,055.60     |
| 6         | RBE117-11181W1P     |                  |         | Main Rotor Drive<br>Mounting Tool<br><br>WO 175881, WO<br>175882, WO 175883<br>WO 175885                   | Firmed | 5/11/12  | 4 Ea           | 0 Ea              | 4 Ea    | \$2,603.98/Ea    | \$10,415.92    |
| 7         | RBW6305G00132-3GP   |                  |         | AW139 Gimbal<br>Bushing<br><br>WO 175863, WO<br>175864, WO<br>175864                                       | Firmed | 5/29/18  | 3 pcs          | 0 pcs             | 3 pcs   | \$1,080.39/pcs   | \$3,241.17     |



**ARROW TECH MACHINE WORKS**

## **Certificate of Conformance**

Your Purchase Order No: 039580

Dated: 5/9/2018

Our Order / Job No: 01AWT

Order Qty: 2

Part Name: FUEL CARTRIDGE PULLER

Part Number: RBEGM-745-064

Lot Size: N/A

Ship Date: 5/9/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBEGM-745-064

Rev:

Material Size and Type: -1,-13,-15,-17,& -19/6061 ALUM; -5/4140 STEEL Q&T;-21/ 1018 STEEL;-23/STRESS PROOF STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29; ALUM.: ASTM B221;STRESS PROOF STEEL: ASTM A108 ASTMA29

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; BLACK OXIDE: QMSI-6.2.2 B.O. REV D

**Mercury Contamination:** The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 05/09/18

Signed: 

**PHGE Machine Works LLC dba Arrow Tech Machine Works**  
**29751 E. Enid Rd. Unit C Eugene, Oregon 97402**  
**Main: (541) 780-6938 | Fax: (458) 215-4938**  
**[www.atechmachineworks.com](http://www.atechmachineworks.com)**

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